

Work Order ID 56834 -1

March 10, 2010 3:50:56 PM

Page 1

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 10/03/2010 Start Qty: 12.00

Required Date: 17/03/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date: 10-3-11 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog

Rev: D 12-Deburr if necessary

304. 062

10-3-16

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-3-16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/03/16

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 56834

March 10, 2010 3:50:56 PM



Page 2

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/03/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00				13	8		
	Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT8179								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	Qty Description Batch A/R 2059B Hardcoat								
	Weld hardcoat as per Dwg D3437								
	M113521								

8/10/03/17

8/10/07/17

(4/17)

EL 10-3-17 (14)

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Work Order ID 56834

March 10, 2010 3:50:56 PM

Page 3

Item ID: D3564-11

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Setup Start

Revision ID:

Stop

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Start Date: 10/03/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00

Customer:




Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	S wlos17						
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S wlos17						(74)
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 1112588 Memo START TIME: 9:30am 10:00a FINISH TIME: 3:20p	0.00 0.00	=1 all 10/03/17						(X4) Ø

OVEN TEMPERATURE:

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Work Order ID 56834

March 10, 2010 3:50:56 PM



Page 4

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	10-3-17			4	0		
200 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	FPA			10-3-17	54	42	
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/03/17 ME 10-3-17

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NOTE: Date & initial all entries

Picklist Print

March 10, 2010 3:51:00 PM

Work Order ID: 56834



Parent Item: D3564-11



Parent Item Name: Wearshoe

Start Date: 10/03/2010

Required Date: 17/03/2010

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Start Qty: 12.00

Required Qty: 12.00

M304S16GA

Purchased No

100 sf

164.3899 17.8105



304/316 Sheet .063



10-3-16

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	164.3898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	101.3049	

13

113295

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56834
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.234	✓			
2.432	+/-0.010	2.431	✓			
2.50	+/-0.030	2.501	✓			
6.000	+/-0.010	6.000	✓			
12.104	+/-0.010	12.104	✓			
18.000	+/-0.010	18.000	✓			
18.00	+/-0.030	18.00	✓			
9.00	+/-0.030	9.00	✓			
11.50	+/-0.030	11.50	✓			
0.300 x 0.300	+/-0.010	300x300	✓			
Ø0.188	+0.005/-0.001	.189	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.068	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-3-16	Date: 10/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

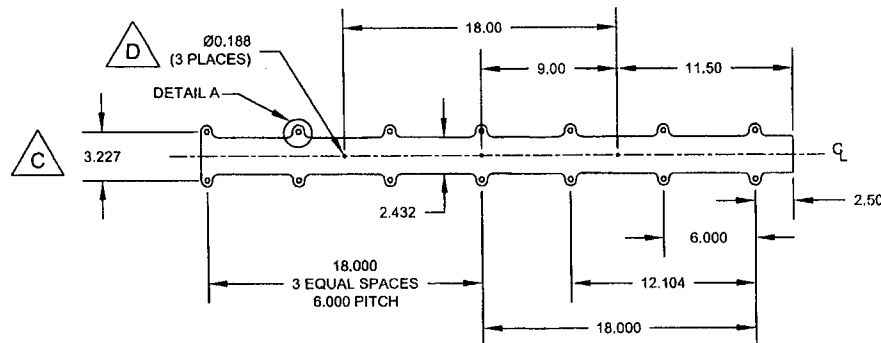
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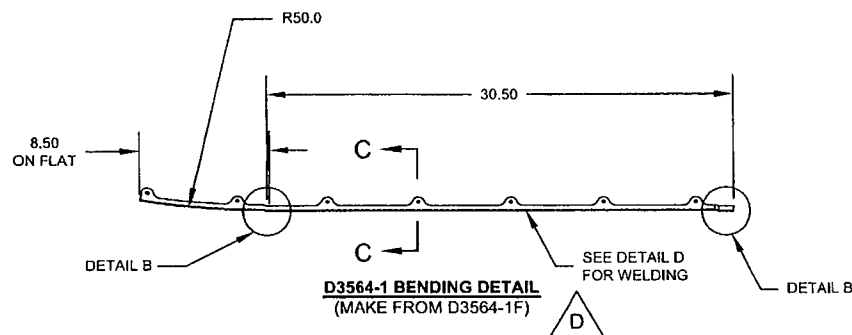
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56834
2810-3-11

RELEASED

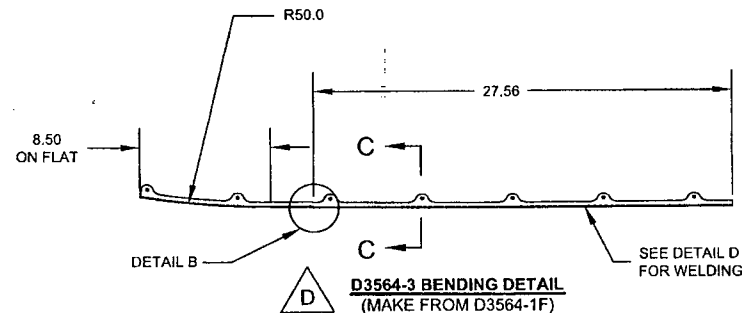
07.09.04 H



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,B2: RELOCATE DETAILS AND SECTION; PG3 A5,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	PH	D3564	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	WEARSHOE	1:	
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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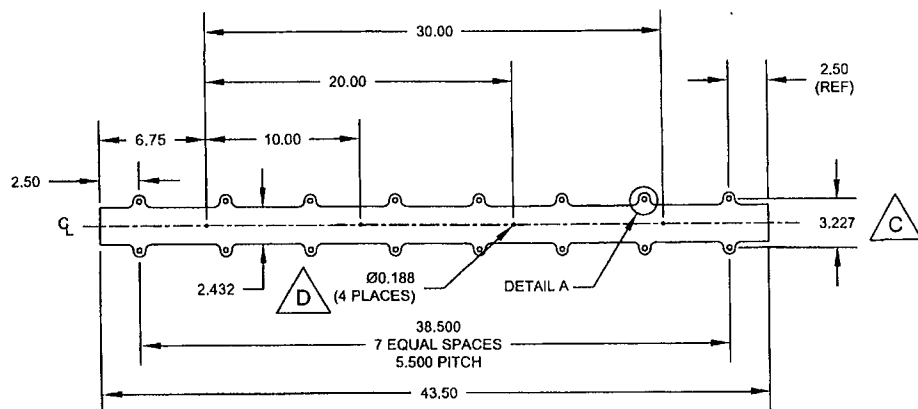
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

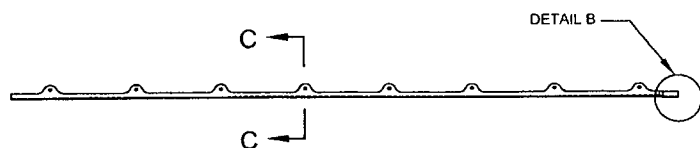
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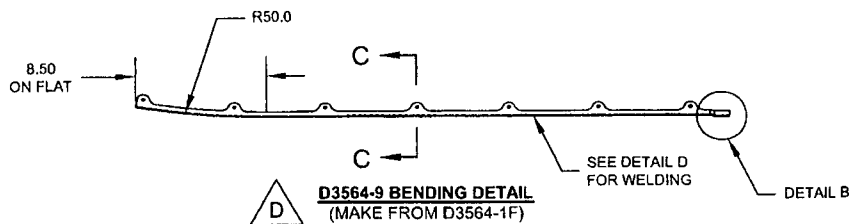
8 7 6 5 4 3 2 1



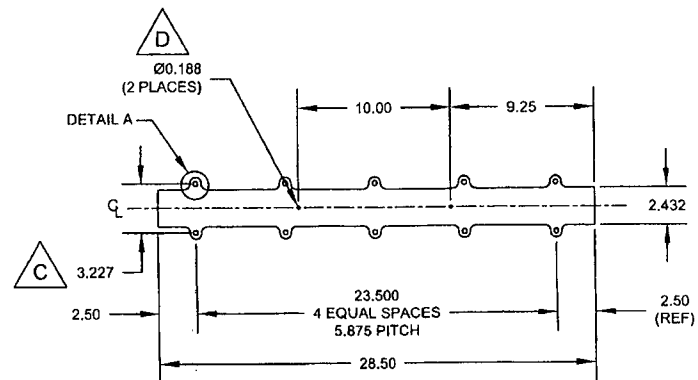
D3564-5F FLAT PATTERN



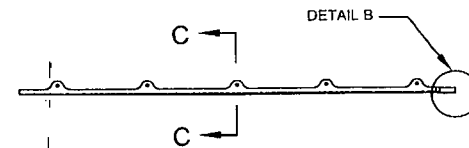
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



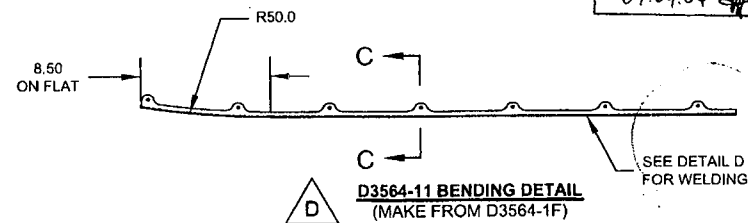
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O 36834

8 7 6 5 4 3 2 1

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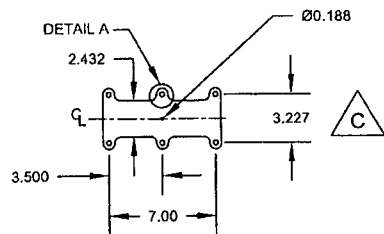
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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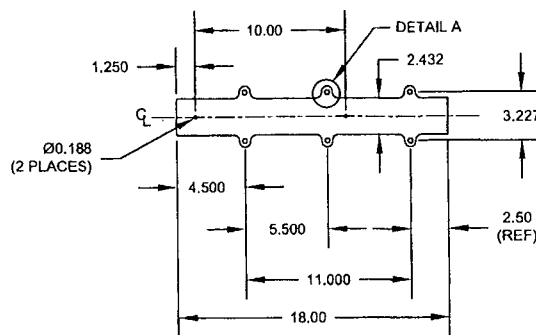
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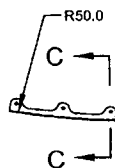
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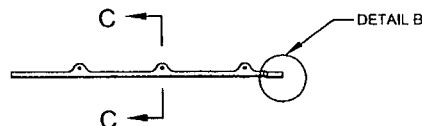
D3564-13F FLAT PATTERN



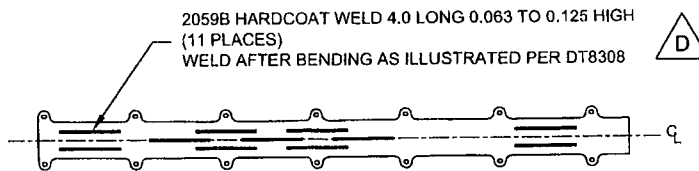
D3564-15F FLAT PATTERN



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



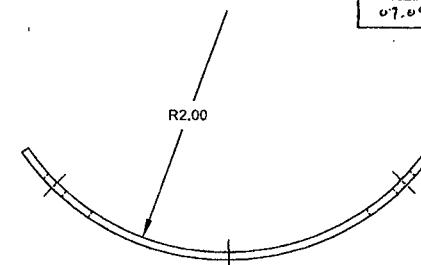
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



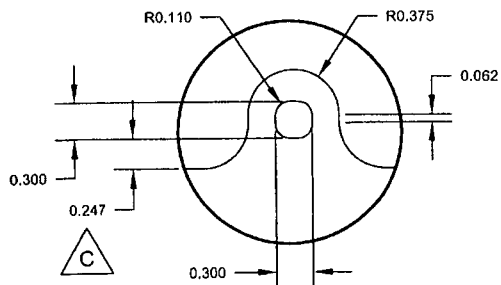
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

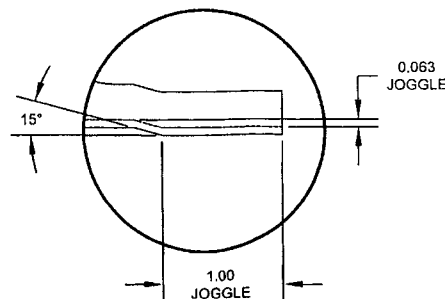
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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8 7 6 5 4 3 2 1

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